



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D3552-11
Job Sheet 204563



Part No: D3552-11 Job Qty: 10 pcs

Part Name: Door Prop



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 12/13/19

Job Tracking No:

Due Date: 1/3/20

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG D3552 Rev M IPP Rev:B 09-04-20 rev.d as per dwg DD verified by:EC IPP Rev:C as per dwg RevE DD 10.02.17 verified by:EC IPP Rev:D 10.12.03 as per dwg rev.G DD ver:EC/ IPP Rev E 18.04.05 Rev M DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier	Sign-off
					Setup Hrs	Run Hrs		
100	Purchasing	10 pcs	1/3/20	1/3/20	0.00	0.00	Purchasing - 1	DEC 24 2019
							Purchasing - 2	
							Purchasing - 3	
110	Packaging 2-1 - Receive - B4B	10 pcs	1/3/20	1/3/20	0.00	0.00	Packaging 2 - 1 - B4B	DEC 24 2019
							Packaging 2 - 2 - B4B	
							Packaging 2 - 3 - B4B	
							Packaging 2 - 5 - B4B	
							Packaging 2 - 4 - B4B	
							Packaging 2 - 6 - B4B	
							Packaging 2 - 7 - B4B	
							Packaging 2 - 8 - B4B	
							Packaging 2 - 9 - B4B	
							Packaging 2 - 10 - B4B	
							Packaging 2 - 11 - B4B	
							Packaging 2 - 12 - B4B	
							Packaging 2 - 13 - B4B	
							Packaging 2 - 14 - B4B	
							Packaging 2 - 15 - B4B	
							Packaging 2 - 16 - B4B	
							Packaging 2 - 17 - B4B	
							Packaging 2 - 18 - B4B	
							Packaging 2 - 19 - B4B	
							Packaging 2 - 20 - B4B	
							Packaging 2 - 21 - B4B	
							Packaging 2 - 22 - B4B	
							Packaging 2 - 23 - B4B	
							Packaging 2 - 24 - B4B	
							Packaging 2 - 25 - B4B	
							Packaging 2 - 26 - B4B	
							Packaging 2 - 27 - B4B	



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S243487



Part: D3552-11

Job No: 204563

Serial No/Batch: S243487

Revision: M

Inspector:

Exp Date:

Instructions: Various STC's

Date: 12/24/19

Plex 12/13/19 8:42 AM Dart.lajeunesse.marie

				Packaging 2 - 28 - B4B	
				Packaging 2 - 29 - B4B	
				Packaging 2 - 30 - B4B	
				Packaging 2 - 31 - B4B	
				Packaging 2 - 32 - B4B	
				Packaging 2 - 33 - B4B	
				Packaging 2 - 34 - B4B	
				Packaging 2 - 35 - B4B	
				Packaging 2 - 36 - B4B	
				120 QC 6	10 pcs
QC 6 - 68	JAN 08 2020 68				
QC 6 - 61	9-88				
QC 6 - 40					
QC 6 - 81					
130 Packaging 3-1 - Stock - B4B	10 pcs	1/3/20	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	DAS
				Packaging 3 - 23 - B4B	84
				Packaging 3 - 24 - B4B	9-89
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
140 QC 21 - SA	10 pcs	1/3/20	0.00 0.00	QC 21 - SA - 21	DAS
				QC 21 - SA - 70	21
				QC 21 - SA - 53	9-82
				Broussard	

Part Op 100 - (Purchasing) Issue P/O: _____ Purchase Part Number: B8-240-575-150N Supplier: LS Technologies

Descriptions: Certificate of conformity is required

110 - (Receive & Inspect for Damage & Mat'l Certs) Ensure certificate of conformity is attached

120 - QC6- All purchased or subcontracted products) Test for correct pressure

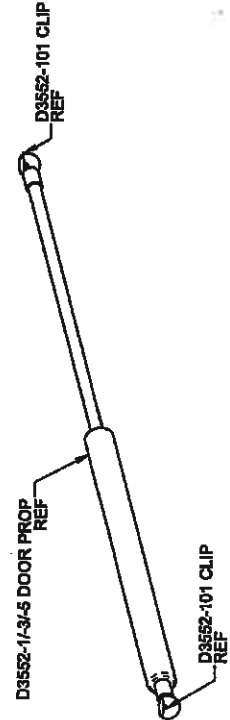
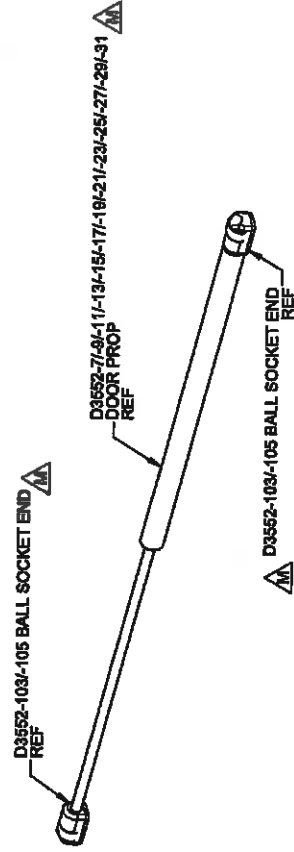
130 - (Identify as per dwg & Stock Location: _____)

140 - (QC21- Final Inspection - Work Order Release)

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
B8-240-575-150N	Gas Spring D3552-11	10 pcs (1 ea)	100-Purchasing	S243486
Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Purchasing	B8-240-575-150N	10	0	0
Part Specifications				
Specifications could not be found.				

Plex 12/13/19 8:42 AM Dart.lajeunesse.marie

SPECIFICATION CONTROL DRAWING



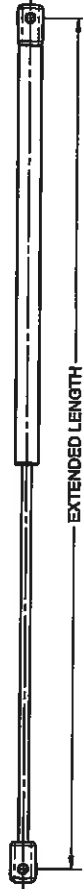
RELEASED
2016 APR 07
E-3 16-65

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 264563 M15

19-12-13

M	ADD PIN D3552-31. SEE CRT18-14, UPDATED PIN D3552-101/102, ADDED PIN D3552-106, REVISED NOTE 3, ADDED NOTE 4.	WK	19.03.20
L	ADD PIN D3552-29	VS	13.04.19
K	ADD "X" TO LS TECHNOLOGIES PNR TO DESIGNATE EXTRA DAMPING FOR D3552-18/-17/-16/-28/-27. REASON: PART 2-308.	MB	12.07.18
J	ADD PIN D3552-28/-27. REMOVE ALTERNATE PART "X" FROM "X" TO LS TECHNOLOGIES PNR. STROKE FOR -15, -17 AND -19 WAS FOR "X" CLIP AND NOT "X" STROKE. STROKE FOR -15, -17 AND -19 WAS 38/112.3 NOT 38/111.3.	AP	11.12.07
I	ADD PIN D3552-23	RF	11.03.11
H	ADD PIN D3552-31	DC	11.03.10
G	FOR -15, FORCE-30087.4 WAS 40098.9, SUPPLIER PIN B8-134-397-300N WAS B8-134-397-400N, FOR -17, STROKE: 38/111.3 WAS 38/112.3, STROKE: 38/111.3 WAS 38/112.3, SUPPLIER PIN B8-134-397-100N WAS B8-134-397-100N.	JPH	10.11.01
F	ADD PIN D3552-15/-17/-19 AND ALTERNATE SUPPLIER	JPH	10.07.27
E	ADD PIN D3552-13 ZN B8-1, AS-1, DS-1, CHANGE NAME FROM "GAS SPRING" TO "DOOR PROP" THROUGH OUT DWG	HS	10.02.03
D	ADD PIN D3552-101 ZN D8-1, G1-1, G1-1 AND D3552-102 ZN D8-1, G1-1 AND G1-1 AND ZN B8-1, ADD NOTE REGARDING D3552-101 AND D3552-102 COMPATIBILITY ZN AS-1	HS	09.04.02
C	ADD D3552-11 AND CONVERSIONS FOR INSPECTION:	LE	07.06.01
B	ADD D3552-74; UPDATE DESC. D3552-14/-5	LE	06.10.24
A	NEW ISSUE	LE	06.09.15
REV.	DESCRIPTION	BY	DATE
DESIGN	VS		
DRAWN	WK		
CHECKED	RF		
MFG. APPR.	RA		
APPROVED	HS		
DE APPR.	DS		
DATE	18.03.20		
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA			
DRAWING NO. D3552			
REV. M			
SHEET 1 OF 2			
TITLE DOOR PROP			
SCALE			
MTS			

Copyright © 2008 by DART Aerospace Ltd.
This document is the property of DART Aerospace Ltd. and is not to be reproduced or transmitted in any form or by any means electronic or mechanical, including photocopying, recording, or by any information storage and retrieval system, without prior written permission from DART Aerospace Ltd.



DART PART NUMBER	DESCRIPTION	STROKE (mm/in)	EXTENDED LENGTH (mm/in)	FORCE (N/lb)	END FITTING	MATERIAL	SUPPLIER	SUPPLIER PART NUMBER OR MODEL NUMBER
D3552-1	DOOR PROP	2208.66	530/20.9	70/15.7	10mm SS BALL SOCKET	CARBON STEEL	LS TECHNOLOGIES	C8-220-530-070N
D3552-3	DOOR PROP	2007.87	490/19.3	200/45.0	10mm SS BALL SOCKET	CARBON STEEL	LS TECHNOLOGIES	C8-200-490-200N
D3552-5	DOOR PROP	1766.99	430/16.9	150/33.7	10mm SS BALL SOCKET	CARBON STEEL	LS TECHNOLOGIES	C8-176-430-150N
D3552-7	DOOR PROP	2208.66	530/20.9	70/15.7	10mm NYLON BALL SOCKET	CARBON STEEL	LS TECHNOLOGIES	B8-220-530-070N
D3552-9	DOOR PROP	2007.87	490/19.3	200/45.0	10mm NYLON BALL SOCKET	CARBON STEEL	LS TECHNOLOGIES	B8-200-490-200N
D3552-11	DOOR PROP	2409.45	576/22.6	150/33.7	10mm NYLON BALL SOCKET	CARBON STEEL	LS TECHNOLOGIES	B8-240-575-150N
D3552-13	DOOR PROP	2208.66	530/20.9	140/31.5	10mm NYLON BALL SOCKET	CARBON STEEL	LS TECHNOLOGIES	B8-220-530-140N
D3552-15	DOOR PROP W/EXTRA DAMPING	1548.08	387/15.2	300/67.4	10mm NYLON BALL SOCKET	CARBON STEEL	LS TECHNOLOGIES	B8-154-387-300NX
D3552-17	DOOR PROP W/EXTRA DAMPING	1548.08	387/15.2	158/35.1	10mm NYLON BALL SOCKET	CARBON STEEL	LS TECHNOLOGIES	B8-154-387-158NX
D3552-19	DOOR PROP W/EXTRA DAMPING	1548.06	387/15.2	60/13.5	10mm NYLON BALL SOCKET	CARBON STEEL	LS TECHNOLOGIES	B8-154-387-060NX
D3552-21	DOOR PROP	1678.57	410/16.1	70/15.7	10mm NYLON BALL SOCKET	CARBON STEEL	LS TECHNOLOGIES	B8-167-410-070N
D3552-23	DOOR PROP	1907.48	475/18.7	70/15.7	10mm NYLON BALL SOCKET	CARBON STEEL	LS TECHNOLOGIES	B8-190-475-070N
D3552-25	DOOR PROP W/EXTRA DAMPING	148/5.93	475/18.7	300/67.4	10mm NYLON BALL SOCKET	CARBON STEEL	LS TECHNOLOGIES	B8-148-475-300NX
D3552-27	DOOR PROP W/EXTRA DAMPING	148/5.93	475/18.7	158/35.1	10mm NYLON BALL SOCKET	CARBON STEEL	LS TECHNOLOGIES	B8-148-475-158NX
D3552-29	DOOR PROP	1907.48	475/18.7	100/22.5	10mm NYLON BALL SOCKET	CARBON STEEL	LS TECHNOLOGIES	B8-190-475-100N
D3552-31	DOOR PROP	1907.48	475/18.7	147/33.0	10mm NYLON BALL SOCKET	CARBON STEEL	LS TECHNOLOGIES	B8-190-475-147N
D3552-101	CLIP	N/A	N/A	N/A	N/A	CARBON STEEL	LS TECHNOLOGIES	C8-8
D3552-103	BALL SOCKET END	N/A	N/A	N/A	N/A	NYLON	LS TECHNOLOGIES	B8
D3552-105	BALL SOCKET END	N/A	N/A	N/A	N/A	NYLON	LS TECHNOLOGIES	B8

D3552-X DOOR PROP

RELEASED

2018 APR 02

- NOTES:
- 1) IDENTIFICATION: IDENTIFY PER QSI 044 8.2
 - 2) D3552-101 CLIP IS ONLY COMPATIBLE WITH D3552-1/3/5 DOOR PROPS
 - 3) D3552-103 BALL SOCKET END IS COMPATIBLE WITH D3552-13/21/23/29/31 DOOR PROPS
 - 4) D3552-105 BALL SOCKET END IS COMPATIBLE WITH D3552-7/9/11/15/17/19/25/27 DOOR PROPS

DESIGN	VS	DART AEROSPACE LTD
DRAWN	WK	HAWKESBURY, ONTARIO, CANADA
CHECKED	RF	DRAWING NO. D3552
MFG. APPR.	RA	REV. M
DE APPR.	HS	SHEET 2 OF 2
DATE	18.03.20	TITLE DOOR PROP
		SCALE NTS

PROPERTY OF DART AEROSPACE LTD
THIS DOCUMENT IS UNCLASSIFIED
DO NOT BE USED FOR ANY PURPOSES OR DISSEMINATED TO ANY OTHERS WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD

NCR No.

Job: _____ Part No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐		DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)			
Description Work Order Deviation				Disposition			
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐				FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Other/Details: _____ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread ☐			
Lead hand / Supervisor				QC / QA Coordinator			



Dart Aerospace Ltd.

1270 Aberdeen St

Hawkesbury, ON

K6A 1K7

Canada

Tel (613) 632-5200

PURCHASE ORDER

POHB045409



Supplier: LST001-VC

LS Technologies Inc.

1634 Saskatchewan Ave.

Saskatoon

SK

S7K 1P6 Canada

Phone: 306 683 5000

Fax: 306 683 6403

Ship To: 1270 Aberdeen Street

Hawkesbury

ON

K6A 1K7 Canada

Phone: 613-632-5200

PO No: POHB045409

PO Date: 12/16/19

Due Date: 12/24/19

Purchase Order Revision: DEC 17 2019

Revision Date:

Ship-To Contact: Lavoie, Chantal

Phone: 613-623-5200 Ext: 242

Fax: 613-632-1053

clavoie@dartaero.com

Via: Ground

Pynt Terms: Net 30

Freight Terms:

Special Comments:

Items														
Line Item	Job	Part	Drawing	Supplier Part No	Item No	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	204561	6/15-164/50-115N				Gas Spring D2807-041 As per Dwg D2807 Rev. E	Firmed X10		12/24/19	10 pcs	0 pcs	10 pcs	\$72.13/pcs	\$721.30
										DEC 24 2019				
2	204563	B8-240-575-150N				Gas Spring D3552-11 As Per Dwg D3552 Rev. M	Firmed X10		12/24/19	10 pcs	0 pcs	10 pcs	\$41.36/pcs	\$413.60
										DEC 24 2019				
Grand Total:														\$1,134.90

Order Notes

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Procurement Quality Clauses

A005 RIGHT OF ENTRY

A007 FIRST ARTICLE INSPECTION (FAI) BY SELLER, (DOCUMENTATION MAINTAINED BY SUPPLIER)

A012 CHEMICAL AND PHYSICAL TEST REPORTS

A016 PERSONNEL QUALIFICATION

A017 RAW MATERIAL IDENTIFICATION (AS APPLICABLE)

A026 CERTIFICATION OF MATERIAL CONFORMANCE

A041 QUALITY MANAGEMENT SYSTEM

A042 DART NOTIFICATION BY SUPPLIER

A043 RETENTION OF QUALITY DOCUMENT

A048 COUNTERFEIT PARTS AVOIDANCE, DETECTION, MITIGATION AND DISPOSITION PROGRAM

A049 SUPPLIER AWARENESS

Plex 12/16/19 11:04 AM Dart.Lavoie.Chantal



LS Technologies Inc

1634 Saskatchewan Ave,
Saskatoon, SK S7K 1P6
Ph: (306) 683-5000 Fax: (306) 683-6403

Certificate of Compliance

Dec 17, 2019

This is to certify that the parts listed below meets specifications as required by your order.

10 Units: D2807-041 #204561 Stainless Gas Spring

10 Units: D3552-11 #204563 Gas Spring

DAS
68
Q.88

Country of Manufacture: Canada

Date of Manufacture: December 2019

This product is ROHS compliant.

Purchase Order # **POHB045409**

Invoice # 21669

L S Technologies Inc Canada

Nolan Fehr
President

Packing Slip

LS TECHNOLOGIES INC
1634 Saskatchewan Ave
Saskatoon, SK S7K 1P6

P.O. No.	Date	Invoice #
POHB045409	2019-12-17	21669

Bill to:

Dart Aerospace Ltd
1270 Aberdeen St.
Hawkesbury, ON K6A 1K7

Ship to:

Main Finished Goods Location
Dart Aerospace Ltd
1270 Aberdeen St.
Hawkesbury, ON K6A 1K7

Ship	Via
2019-12-17	Fed-Ex

Qty	Description
10	D2807-041 #204561 Stainless Gas Spring (6/15-164/50-115N)
10	D3552-11 #204563 Gas Spring
Shipping Via FED EX Tracking # 777277226470	
RECEIVED DEC 23 2019 DART AEROSPACE LTD.	

Order checked by

